

Amendments to the Claims:

Claims 1, 2, 4-16, and 18-29 were pending at the time of the Office Action.

Claims 1, 2, 15 and 20 are amended, and claims 12 and 18-19 are canceled.

Claims 1, 2, 4-11, 13-16, and 20-29 remain pending.

1. (Currently Amended) A method for changing a property of a layer-formed plastic part comprised of at least one plastic material, the method comprising:

forming ~~providing~~ a first plurality of layers of a partially completed layer-formed plastic part, the first plurality of layers being formed using at least one of selective laser sintering (SLS) and fused deposition modeling (FDM);

providing an electromagnetic radiation source, the electromagnetic radiation source being at least one of an electron beam, an ultraviolet light source, and a radioactive material;

positioning the partially completed layer-formed plastic part within a potential exposure range of the electromagnetic radiation source;

forming a second plurality of layers adjacent the first plurality of layers using at least one of selective laser sintering and fused deposition modeling;

after the layer-formed plastic part including the first plurality of layers and the second plurality of layers has been formed, determining an exposure of radiation from the electromagnetic radiation source operable to change a second-layer property of the second plurality of layers of the layer-formed plastic part from an existing state to an altered state without substantially changing a first-layer property of the first plurality of layers; and exposing the second plurality of layers of the layer-formed plastic part to the exposure of radiation to change the second-layer property of the second

plurality of layers to the altered state.

2. (Currently Amended) The method of Claim 1, wherein determining the exposure of radiation from the electromagnetic radiation source operable to change the second-layer property of the layer-formed plastic part from the existing state to the altered state includes:

recognizing the existing state of the second-layer property of the second plurality of layers of the layer-formed part;
identifying a desired state of the second-layer property;
identifying the exposure of radiation to change the second-layer property of the second plurality of layers of the layer-formed plastic part such that the altered state reaches the desired state.

3. (Cancelled)

4. (Original) The method of Claim 1, wherein the exposure of electromagnetic radiation is controlled by relative movement of the layer-formed plastic part and the electromagnetic radiation source.

5. (Original) The method of Claim 4, wherein the layer-formed plastic part is moved relative to the source of the electromagnetic radiation.

6. (Original) The method of Claim 4, wherein the source of the electromagnetic radiation is moved relative to the layer-formed plastic part.

7. (Original) The method of Claim 4, wherein the exposure of radiation is controlled by at least partially directing a discharge of radiation from the electromagnetic radiation source.

8. (Original) The method of Claim 7, wherein the exposure of radiation is

controlled by manipulating at least one magnetic field through which the radiation from the electromagnetic radiation source will pass.

9. (Original) The method of Claim 1, wherein the exposure of radiation is controlled by selectively positioning a radiation-blocking shield between the layer-formed plastic part and the electromagnetic radiation source such that at least part of the layer-formed plastic part is shielded from the radiation source.

10. (Previously Presented) The method of Claim 1, wherein the second-layer property to be changed is one of physical strength, elongation, modulus, impact resistance, operating temperature range, heat capacity, flammability, conductance, and emittance.

11. (Original) The method of Claim 10, wherein the electromagnetic radiation source and the exposure of radiation are selected to at least one of cross-link and chain-scission molecules of the plastic material to change the property of the layer-formed plastic part to the desired state.

12. (Cancelled)

13. (Original) The method of Claim 1, further comprising forming an additional layer upon the layer-formed plastic part after the exposure of radiation has been applied.

14. (Original) The method of Claim 13, further comprising exposing the additional layer to a secondary exposure of radiation.

15. (Currently Amended) A method for producing a layer-formed plastic part comprised of at least one plastic material, the method comprising:

successively forming a plurality of layers ~~first layer~~ of a layer-formed plastic part;

~~forming a second layer adjacent the first layer;~~

after the layer-formed plastic part including the plurality of layers has been formed, determining an exposure of radiation from an electromagnetic radiation source operable to change a second-layer property of a second portion of the plurality of layers ~~the second layer~~ from an existing state to an altered state without changing a first-layer property of a first portion of the plurality of layers ~~the first layer~~; and

exposing the second portion of the plurality of layers ~~second layer~~ to the exposure of radiation to change the second-layer property to the altered state without changing the first-layer property of the first portion of the plurality of layers; and

varying the exposures of radiation to which the first portion of the plurality of layers and the second portion of the plurality of layers are exposed to differently change the properties of respective layers of the first and second portions.

16. (Previously Presented) The method of Claim 15, wherein determining the exposure of radiation from the electromagnetic radiation source operable to change the second-layer property of the layer-formed plastic part from the existing state to the altered state includes:

recognizing the existing state of the second-layer property of the second layer;
identifying a desired state of the second-layer property;
identifying the exposure of radiation to change the second-layer property of
the second layer such that the altered state reaches the desired state.

17. (Cancelled)

18. (Cancelled)

19. (Cancelled)

20. (Currently Amended) The method of Claim 15 +8, wherein exposing the second portion includes exposing the second portion using an electromagnetic radiation source that includes at least one of an electron beam and an x-ray exposure, further comprising varying the electromagnetic radiation source to differently change the properties of respective layers associated with the first and second portions.

21. (Previously Presented) The method of Claim 15, wherein the exposure of electromagnetic radiation is controlled by relative movement of the second layer and the electromagnetic radiation source.

22. (Previously Presented) The method of Claim 21, wherein the second layer is moved relative to the source of the electromagnetic radiation.

23. (Previously Presented) The method of Claim 21, wherein the source of the electromagnetic radiation is moved relative to the second layer.

24. (Original) The method of Claim 15, wherein the exposure of radiation is controlled by targeting discharge of radiation from the electromagnetic radiation source.

25. (Original) The method of Claim 24, wherein the exposure of radiation is

controlled by manipulating at least one magnetic field.

26. (Original) The method of Claim 15, wherein the exposure of radiation is controlled by selectively positioning a radiation-blocking shield between the layer-formed plastic part and the electromagnetic radiation source such that at least part of the layer-formed plastic part is shielded from the radiation source.

27. (Original) The method of Claim 15, wherein the property to be changed is one of physical strength, elongation, modulus, impact resistance, operating temperature range, heat capacity, flammability, conductance, and emittance.

28. (Original) The method of Claim 27, wherein the electromagnetic radiation source and the exposure of radiation are selected to at least one of cross-link or chain-scission molecules of the plastic material to change the property of the layer-formed plastic part to the desired state.

29. (Original) The method of Claim 15, wherein the electromagnetic radiation is provided by one of an electron beam, an ultraviolet light source, or a radioactive material.

30. (Withdrawn) A system for changing a property of a layer-formed plastic part comprised of at least one plastic material, the system comprising:

- an electromagnetic radiation source;

- a part presentation device configured to receive the layer-formed plastic part and present the layer-formed plastic part to the electromagnetic radiation source; and

- an exposure control device operably coupled with at least one of the electromagnetic radiation source and the part presentation device, the exposure control device being configured to selectively expose the layer-formed plastic part to an exposure of radiation generated by the

electromagnetic radiation source.

31. (Withdrawn) The system of Claim 30, wherein the layer-formed plastic part is formed using at least one of selective laser sintering and fused deposition modeling.

32. (Withdrawn) The system of Claim 30, wherein the exposure control device selectively exposes the layer-formed plastic part to the electromagnetic radiation source by moving at least one of the part presentation device and the electromagnetic radiation source.

33. (Withdrawn) The system of Claim 30, further comprising a radiation directing device configured to direct a discharge of radiation from the electromagnetic radiation source.

34. (Withdrawn) The system of Claim 33, wherein the radiation directing device includes a magnetic channeling system configured to direct the discharge of radiation by manipulating a magnetic field.

35. (Withdrawn) The system of Claim 30, further comprising a radiation-blocking shield configured to be positioned between the layer-formed plastic part and the electromagnetic radiation source such that at least part of the layer-formed plastic part is shielded from the radiation source.

36. (Withdrawn) The system of Claim 30, wherein the property to be changed is one of physical strength, elongation, modulus, impact resistance, operating temperature range, heat capacity, flammability, conductance, and emittance.

37. (Withdrawn) The method of Claim 36, wherein the electromagnetic radiation source and the exposure of radiation are selected to at least one of cross-link and chain-scission molecules of the plastic material to change the property of the layer-formed

plastic part to the desired state.

38. (Withdrawn) The system of Claim 30, wherein the electromagnetic radiation source is one of an electron beam, an ultraviolet light source, or a radioactive material.

39. (Withdrawn) The system of Claim 30, further comprising a layering production system operable to create the layer-formed plastic part such that a layer of the layer-formed plastic part is selectively exposed to the exposure of radiation then an additional layer is formed upon the layer-formed plastic part such that the additional layer is not subjected to the exposure of radiation.

40. (Withdrawn) A system for producing a layer-formed plastic part comprised of at least one plastic material, the method comprising:

- a layer-forming production device configured to produce the layer-formed plastic part by forming at least one layer of plastic material;
- an electromagnetic radiation source;
- a part presentation device configured to receive the layer-formed plastic part and present the layer-formed plastic part to the electromagnetic radiation source;
- an exposure control device operably coupled with at least one of the electromagnetic radiation source and the part presentation device, the exposure control device being configured to selectively expose the at least one layer of the layer-formed plastic part to an exposure of radiation generated by the electromagnetic radiation source; and
- a control unit operably coupled with the layer-forming production device and the exposure control device, the control unit being configured to selectively direct the at least one layer to be exposed to the exposure of radiation after the forming of the at least one layer.

41. (Withdrawn) The system of Claim 40, wherein the layer-forming production device produces the layer-formed plastic part using at least one of selective laser sintering and fused deposition modeling.

42. (Withdrawn) The system of Claim 40, wherein the exposure control device selectively exposes the layer-formed plastic part to the electromagnetic radiation source by moving at least one of the part presentation device and the electromagnetic radiation source.

43. (Withdrawn) The system of Claim 40, further comprising a radiation directing device configured to direct a discharge of radiation from the electromagnetic radiation source.

44. (Withdrawn) The system of Claim 43, wherein the radiation directing device includes a magnetic channeling system configured to direct the discharge of radiation by manipulating a magnetic field.

45. (Withdrawn) The system of Claim 40, further comprising a radiation-blocking shield configured to be positioned between the layer-formed plastic part and the electromagnetic radiation source such that at least part of the layer-formed plastic part is shielded from the radiation source.

46. (Withdrawn) The system of Claim 40, wherein the property to be changed is one of physical strength, elongation, modulus, impact resistance, operating temperature range, heat capacity, flammability, conductance, and emittance.

47. (Withdrawn) The method of Claim 46, wherein the electromagnetic radiation source and the exposure of radiation are selected to at least one of cross-link or chain-scission molecules of the plastic material to change the property of the layer-formed

plastic part to the desired state.

48. (Withdrawn) The system of Claim 40, wherein the electromagnetic radiation source is one of an electron beam, an ultraviolet light source, or a radioactive material.